



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200
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D3492-3
Job Sheet 197885



Part No: D3492-3

Job Qty: 120 pcs **123**

Part Name: Plug



Part Weight: 0 lbs

Job Created: 7/18/19

Due Date: 7/30/19

Type: Stock

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: DWG REV E IPP Rev:A 11.04.19 per dwg revC DD ver:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Hardinge - 1	120 pcs		7/30/19	0.00	4.49	Hardinge - 1		BM, 19-08-14
120	QC 8	120 pcs		7/30/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		19-08-14
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Handfinish - 1-1 Chemical-B4B	120 pcs		7/30/19	0.00	0.41	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 -		AUG 16 2019



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CANADA
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Container No: S205435



Part: D3492-3

Job No: 197885

Serial No/Batch: S205435

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/14/19

Plex 7/18/19 8:45 AM Dart.lajeunesse.marie

				B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
140	Powdercoat - 1 White Gl(A)- B4B	120 pcs	7/30/19	0.00 0.24	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
150	QC 3	120 pcs	7/30/19	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19
					QC 3 - 43

START: 11:15 O.U.T. 370° FINISH: 11:45

BL 19-8-00.

DAS 40
AUG 22 2019 9-89

160 Packaging 3-1 - Stock - B4B	120 pcs	7/30/19	0.00 0.00	QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	ML
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	

170 QC 21 - SA		120 pcs	7/30/19	0.00 0.00	Packaging 3 - 36 - B4B	
					QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	
Part Op 100 - (Hardinge) 1-Turn as per Folio FA632 & Dwg D3492						
Descriptions: 120 - (QC8- Inspect parts - second check)						
130 - (Chemical Conversion Coat per QSI005 4.1)						
140 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) (Flat End Only)						
150 - (QC3- Inspect Part Finish)						
160 - (Identify as per dwg & Stock Location:) LOCATION : FP001						
170 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
M6061T6R0.750	6061-T6 Round Bar .750"	7.0800 ft (.059 ea)	100-Hardinge - 1	S170076		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Hardinge - 1	M6061T6R0.750	7	32	0		
Part Specifications						
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments	
1	Plug	0.750inches ± 0.010	0.760 0.740	0.741		
2	Plug	0.582inches + 0.000 - 0.002	0.582 0.580	0.581		
3	Plug	0.045inches + 0.000 - 0.002	0.045 0.043	0.045		
4	Plug	0.060inches ± 0.005	0.065 0.055	0.062		
5	Plug	0.060inches ± 0.005	0.065 0.055	0.062		
6	Plug	0.500inches ± 0.010	0.510 0.490	0.502		
7	Plug	0.090inches + 0.000 - 0.002	0.090 0.088	0.0885		

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MAT
used
6.946'

Entered:

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ Cross tube ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ Machining ☐ ☐ ☐ Small Fab ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ Large Fab ☐ ☐ ☐ Finishing ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ Engineering ☐ ☐ ☐ Water Jet ☐ ☐ ☐ Supplier ☐ ☐ ☐ Quality ☐ ☐ ☐						Date : _____ Sequence #: _____		QTY Affected : _____		MRB (QSI042) ☐ ☐ ☐	
Description Work Order Deviation				Disposition											
Completed By				Lead hand / Supervisor											
								QC / QA Coordinator							
Root Cause Operator ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ Material ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ Human Factors ☐ ☐ ☐				FAULT CATEGORY Contamination ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ Fit/Function ☐ ☐ ☐				Pressure/Forced ☐ ☐ ☐ Bending ☐ ☐ ☐ Crushing ☐ ☐ ☐ Cracks ☐ ☐ ☐ Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ Marks/Chatter ☐ ☐ ☐ Mislabeled ☐ ☐ ☐				Power Loss/Surge ☐ ☐ ☐ Folio/Program ☐ ☐ ☐ Grain Direction ☐ ☐ ☐ Weld ☐ ☐ ☐ Wrong Stock Pulled ☐ ☐ ☐ Out of Sequence ☐ ☐ ☐ Off-set/Set-up ☐ ☐ ☐			
Other/Details:				Positioned Wrong ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ Drawing ☐ ☐ ☐ Finish ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ Misread ☐ ☐ ☐											